



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBWA353A04
Job Sheet 184187



Part No: RBWA353A04

Job Qty: 2 pcs

Part Name: Pmc Oil Filling Quick Disconnect



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/3/18

Job Tracking No:

Due Date: 11/26/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBWA353A04 Rev 4 IPP Rev A 18.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	11/26/18		0.00	2.00	Small Fab - 1		MLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	2 pcs	11/26/18		0.00	0.00	QC 5 - 10		DAS 30 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	2 pcs	11/26/18		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartara.com
www.dartaerospace.com

Container No: S147706

Part: FBWA353A04

Job No: 184187

Serial No/Batch: S147706

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 01/24/19

					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	MLC
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	2 pcs	11/26/18	0.00 0.00	QC 21 - SA - 21	QC 21 - SA - 70	DAG 21 JAN 24 2019 9-88

Part Op 110 - Small Fab - 1-Assemble as per DWG. Sheet . 2-Engrave 1632T22 tag using marktronic engraver as per DWG. 3-Descriptions: Fabricate and attach lanyard as per DWG.

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
78 1632T22	Aluminum Tag 1" X 2" X 0.04"	2 pcs (1 ea)	110-Small Fab - 1	5418668
27 2619	Spring Rnd 3/4"	2 Ea (1 ea)	110-Small Fab - 1	5075045
3896T31	Ferule 1/16 X 3/8" - Aluminum	4 Ea (2 ea)	110-Small Fab - 1	5038398
44 50715K179	Female Pipe Adapter SS	2 Ea (1 ea)	110-Small Fab - 1	5118706
52 91665A350	Retaining Ring, 7/16" Shaft	2 Ea (1 ea)	110-Small Fab - 1	50410064
47 9262K613	O-Ring 13mm OD x 1mm	2 Ea (1 ea)	110-Small Fab - 1	5046049
CL-2-C	Lanyard Wire	.8400 ft (.42 ea)	110-Small Fab - 1	5093863
137 RBWA353A04-01	Cap	2 Ea (1 ea)	110-Small Fab - 1	5061607
RBWA353A04-02	Sleeve	2 Ea (1 ea)	110-Small Fab - 1	5146133
137 RBWA353A04-03	Barb	2 pcs (1 ea)	110-Small Fab - 1	5140141
RBWA353A04-05	Quill	2 pcs (1 ea)	110-Small Fab - 1	5136861
RBWA353A04-06	Cap	2 pcs (1 ea)	110-Small Fab - 1	5061857
93 RBWA353A04-07	Valve	2 pcs (1 ea)	110-Small Fab - 1	5137129
94 RBWA353A04-08	Screw (Modified B/O)	4 pcs (2 ea)	110-Small Fab - 1	5057743
25 S1030	Spring .025 Wire: .300 O.D X .5 free length	2 Ea (1 ea)	110-Small Fab - 1	5078889

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	1632T22	2	96	0
	2619	2	40	0
	3896T31	4	618	0
	50715K179	2	9	0
	91665A350	2	19	0
	9262K613	2	85	0
	CL-2-C	1	493	0
	RBWA353A04-01	2	3	0
	RBWA353A04-02	2	12	0
	RBWA353A04-03	2	14	0
	RBWA353A04-05	2	13	0
	RBWA353A04-06	2	3	0
	RBWA353A04-07	2	13	0
	RBWA353A04-08	4	19	0
	S1030	2	7	0
Part Specifications				
Specifications could not be found.				

Plex 1/23/19 2:49 PM Dart.Hadley.Shannon



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBWA353A04
Job Sheet 184187



Part No: RBWA353A04

Job Qty: 1 ea

Part Name: Pmc Oil Filling Quick Disconnect



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/3/18

Job Tracking No:

Due Date: 11/26/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBWA353A04 Rev 4 IPP Rev A 18.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/26/18	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	1 pcs		11/26/18	0.00	1.00	Small Fab-3		
120	QC	1 pcs		11/26/18	0.00	0.00	QC5		
130	Packaging	1 pcs		11/26/18	0.00	0.00	Packaging3-1		
140	QC21-SA	1 Ea		11/26/18	0.00	0.00	QC21		

Part Op 110 - 1-Assemble as per DWG. Sheet . 2-Engrave 1632T22 tag using marktronic engraver as per DWG. 3-Fabricate and Descriptions: attach lanyard as per DWG.

Job BOM

	Part / Item	Component Name	Quantity	Operation	Container
78	1632T22	Aluminum Tag 1" X 2" X 0.04"	1 pcs (1 ea)	90-Start up Operation	
27	2619	Spring Rnd 3/4"	1 Ea (1 ea)	90-Start up Operation	
26	3896T31	Ferule 1/16 X 3/8" - Aluminum	2 Ea (2 ea)	90-Start up Operation	
44	50715K179	Female Pipe Adapter SS	1 Ea (1 ea)	90-Start up Operation	
52	91665A350	Retaining Ring, 7/16" Shaft	1 Ea (1 ea)	90-Start up Operation	
47	9262K613	O-Ring 13mm OD x 1mm	1 Ea (1 ea)	90-Start up Operation	
	CL-2-C	Lanyard Wire	.4200 ft (.42 ea)	90-Start up Operation	
137	RBWA353A04-01	Cap	1 Ea (1 ea)	90-Start up Operation	
137	RBWA353A04-02	Sleeve	1 Ea (1 ea)	90-Start up Operation	
	RBWA353A04-03	Barb	1 Ea (1 ea)	90-Start up Operation	
137	RBWA353A04-05	Quill	1 Ea (1 ea)	90-Start up Operation	
137	RBWA353A04-06	Cap	1 Ea (1 ea)	90-Start up Operation	
93	RBWA353A04-07	Valve	1 Ea (1 ea)	90-Start up Operation	
94	RBWA353A04-08	Screw (Modified B/O)	2 Ea (2 ea)	90-Start up Operation	
25	S1030	Spring .025 Wire: .300 O.D X .5 free length	1 Ea (1 ea)	90-Start up Operation	

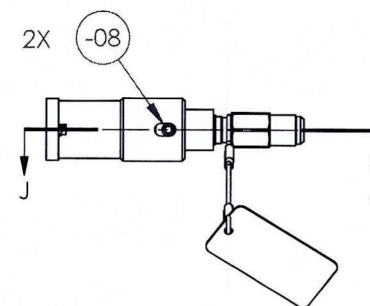
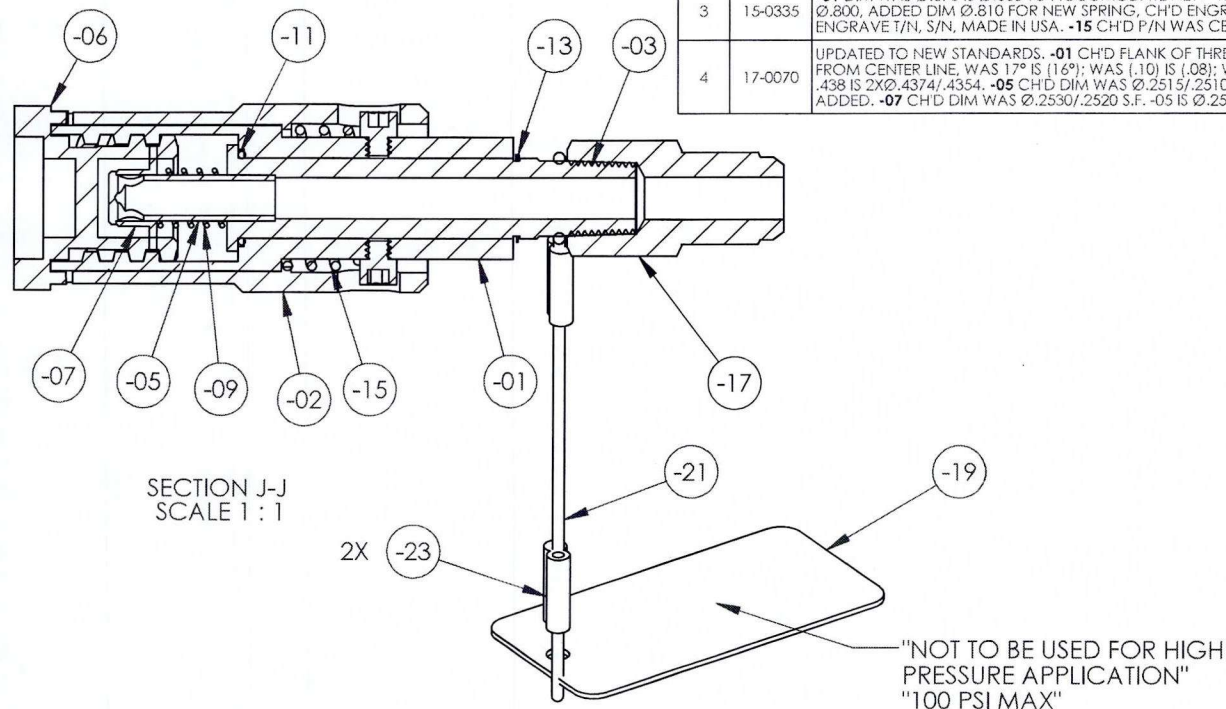
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	1632T22	1	123	0
	2619	1	45	0
	3896T31	2	600	0
	50715K179	1	11	0
	91665A350	1	24	0
	9262K613	1	87	0
	CL-2-C	0	475	0
	RBWA353A04-01	1	5	0
	RBWA353A04-02	1	2	0
	RBWA353A04-03	1	0	0
	RBWA353A04-05	1	15	0
	RBWA353A04-06	1	5	0
	RBWA353A04-07	1	15	0
	RBWA353A04-08	2	23	0
	S1030	1	9	0
Part Specifications				
Specifications could not be found.				

Plex 12/22/18 1:48 PM dart.leclair.mathieu

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		REDESIGNED ASSEMBLY	2/22/2011	JAG	
2		DELETED -19, -21, & -23 CH'D -15 FROM HOSE & -17 FROM HOSE CLAMP. ADDED -19, -21, & -23. -01 CH'D TO CLEAR ANODIZE. -02 CH'D TO CLEAR ANODIZE. CH'D -03 THRU HOLE FROM Ø.17, CH'D DESIGN ADDED 1/8 NPT-27 FOR FITTING. CH'D -05 ID FROM Ø.14 & CH'D LIMIT DIMENSION FROM Ø.2510-.2514 S.F. -07, CH'D -07 ID LIMIT DIM. FROM Ø.2515-.2520 & S.F. -05 PER D.W.	1/17/2012	RJC	DW
2A		-03 REMOVED X.50 DEPTH FROM 1/8 NPT	1/3/2013	BIM	GE
3	15-0335	-01 DIM WAS Ø.675 IS Ø.665 TO ACCOMMODATE NEW -15 SPRING. -02 CH'D DIM WAS 2X Ø.800 IS Ø.800, ADDED DIM Ø.810 FOR NEW SPRING, CH'D ENGRAVE NOTE WAS ENGRAVE T/N TO FIT IS ENGRAVE T/N, S/N, MADE IN USA. -15 CH'D P/N WAS CENTURY SPRING #B15-66 IS 2619.	10/13/2015	RJC	JAG
4	17-0070	UPDATED TO NEW STANDARDS. -01 CH'D FLANK OF THREAD START WAS ON CENTERLINE, IS 5° OFFSET FROM CENTER LINE, WAS 17° IS (1.6°); WAS (.10) IS (.08); WAS .101 IS .100. -03 CH'D DIM WAS 2X Ø.438 IS 2X Ø.4374/.4354. -05 CH'D DIM WAS Ø.2515/.2510 S.F. -07 IS Ø.2515/.2510 (S.F. -07). -06 ADDED. -07 CH'D DIM WAS Ø.2530/.2520 S.F. -05 IS Ø.2530/.2520 (S.F. -05).	3/21/2017	SM	JAG



B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	-01	1	CAP	6061		2
	-02	1	SLEEVE	6061		3
	-03	1	BARB	303/304 S.S.		4
	-05	1	QUILL	303/304 S.S.		5
	-06	1	CAP	6061		6
	-07	1	VALVE	303/304 S.S.		7
	-08	2	SCREW	S.S.	6-32 X 1/8 (MCMMASTER-CARR #92196A139) MODIFIED	8
B/O	-09	1	SPRING	MUSIC WIRE	Ø.025 WIRE: Ø.300 OD X .5 FREE LENGTH (RIED #S1030)	1
B/O	-11	1	O-RING	BURNA-N	Ø13mm OD X 1mm (MCMMASTER-CARR #9262K613)	1
B/O	-13	1	EXTERNAL RETAINING RING	SPRING STEEL	Ø7/16 SHAFT (MCMMASTER-CARR #91665A350)	1
B/O	-15	1	SPRING	SPRING STEEL	Ø.78 (CENTURY SPRING #2619)	1
B/O	-17	1	FEMALE PIPE ADAPTER	S.S.	MCMMASTER-CARR #50715K179	1
	-19	1	TAG	ALUMINUM	1/32 X 1 X 2	1
B/O	-21	1	LANYARD	COATED GALV. STEEL	(7X7 CABLE) Ø1/16 X 5in. (CARR LANE #CL-2-2)	1
B/O	-23	2	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMMASTER-CARR #3896T31)	1



TITLE
PMC OIL FILLING QUICK DISCONNECT

DWG NO. RBWA353A04

REV
4

MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: GILBERT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DD 03/22/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 03/28/2017	USED ON MODEL
QA APPR: JL 03/29/2017	AGUSTA HELICOPTERS
APPROVED: JAG 04/03/2017	
SCALE 1:3	DATE 2/22/2011
	SHEET 1 OF 8